

Date: Tuesday, 12/6/2005 9:24:45 AM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR PROTCTOR FWD RH
<b>Job Number</b> : 25121	
<b>Estimate Number</b> : 11234	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D32812
<b>This Issue</b> : 12/6/2005 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D3281 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : <i>N/A</i>	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>SEE COMMENT BELOW</i>	<b>Due Date</b> : 12/30/2005 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>SEE COMMENT BELOW</i>	
<b>Comment</b> : Est Rev:A 04.07.01 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *192*

Description: Floor Protector RH

Possible Supplier: Delastek

Certificate of Conformity is required

*u 051206*

2.0	D32812	Floor Protector, Fwd RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
Floor Protector, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

*u 6/1/30*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

*u 6/1/31 (20)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*u 6/1/31 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 19 Date: 06/02/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/6/2005 9:24:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCOR FWD RH

Job Number: 25121

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/01

(20)

DP

06/02/01

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

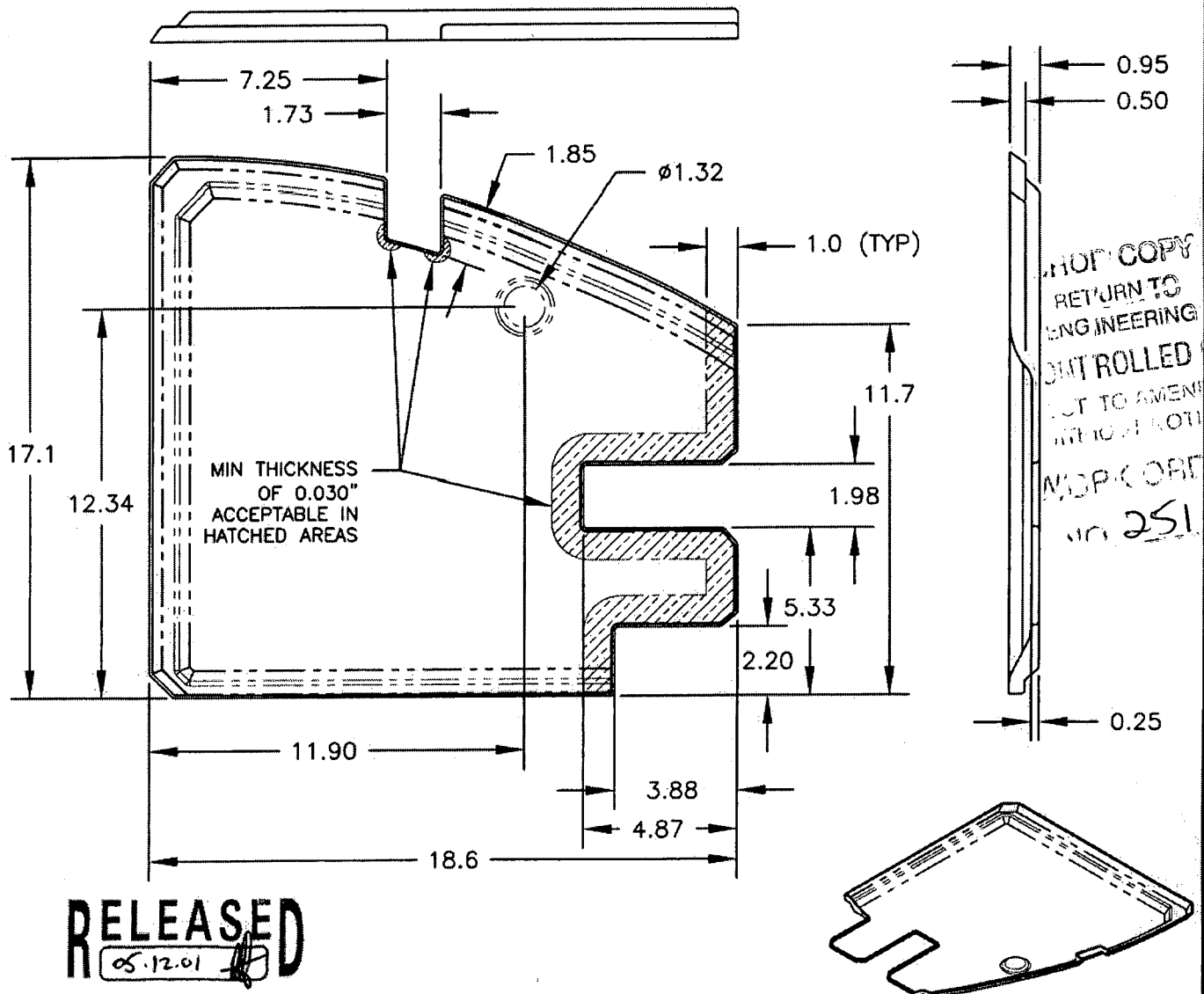
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**D3281-1 FLOOR PROTECTOR, FWD LH**

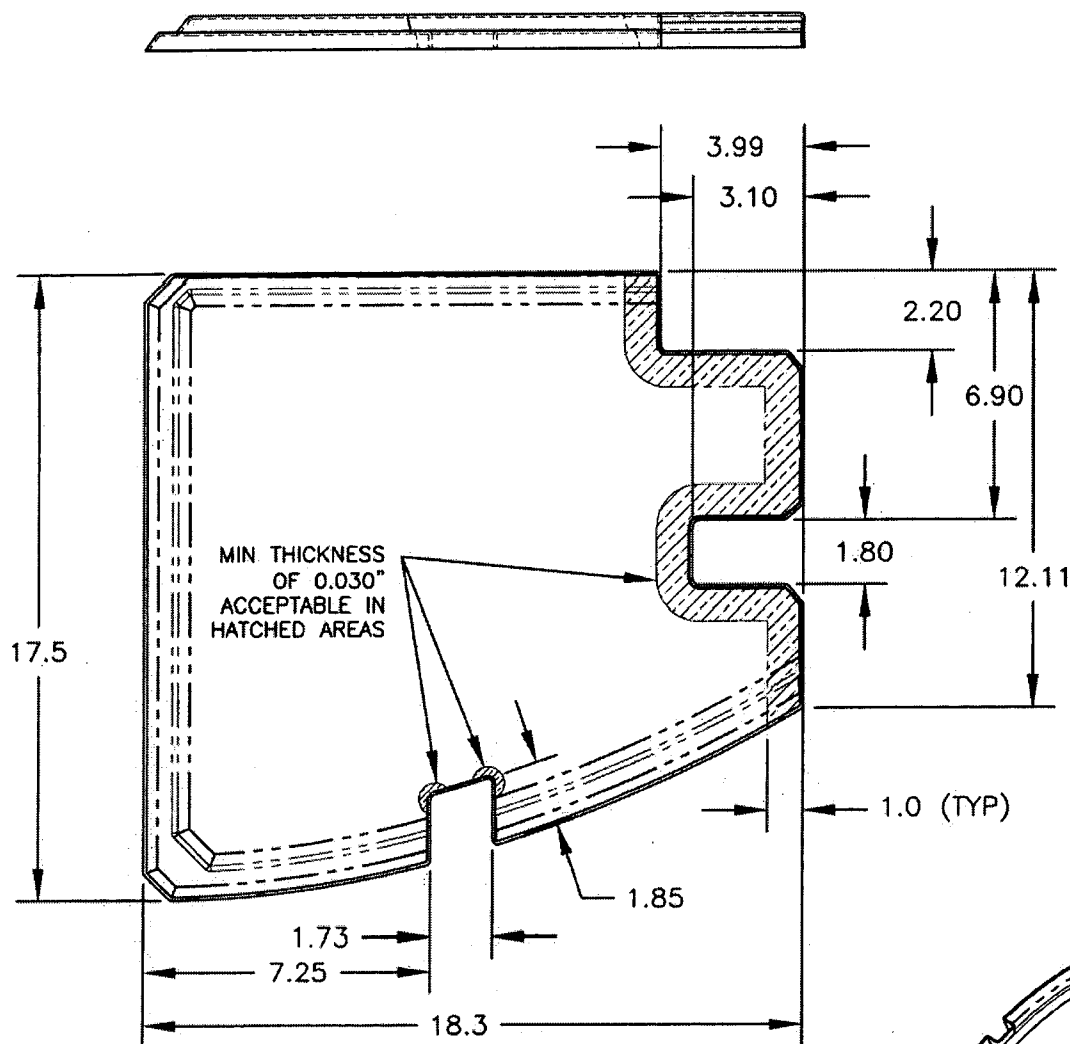
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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**DART**

DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



NOT TO SCALE  
FOR TECHNICAL  
ENGINEERING  
ONLY  
WORK C  
NO. 25121

RELEASED  
05.12.01

**D3281-2 FLOOR PROTECTOR, FWD RH**

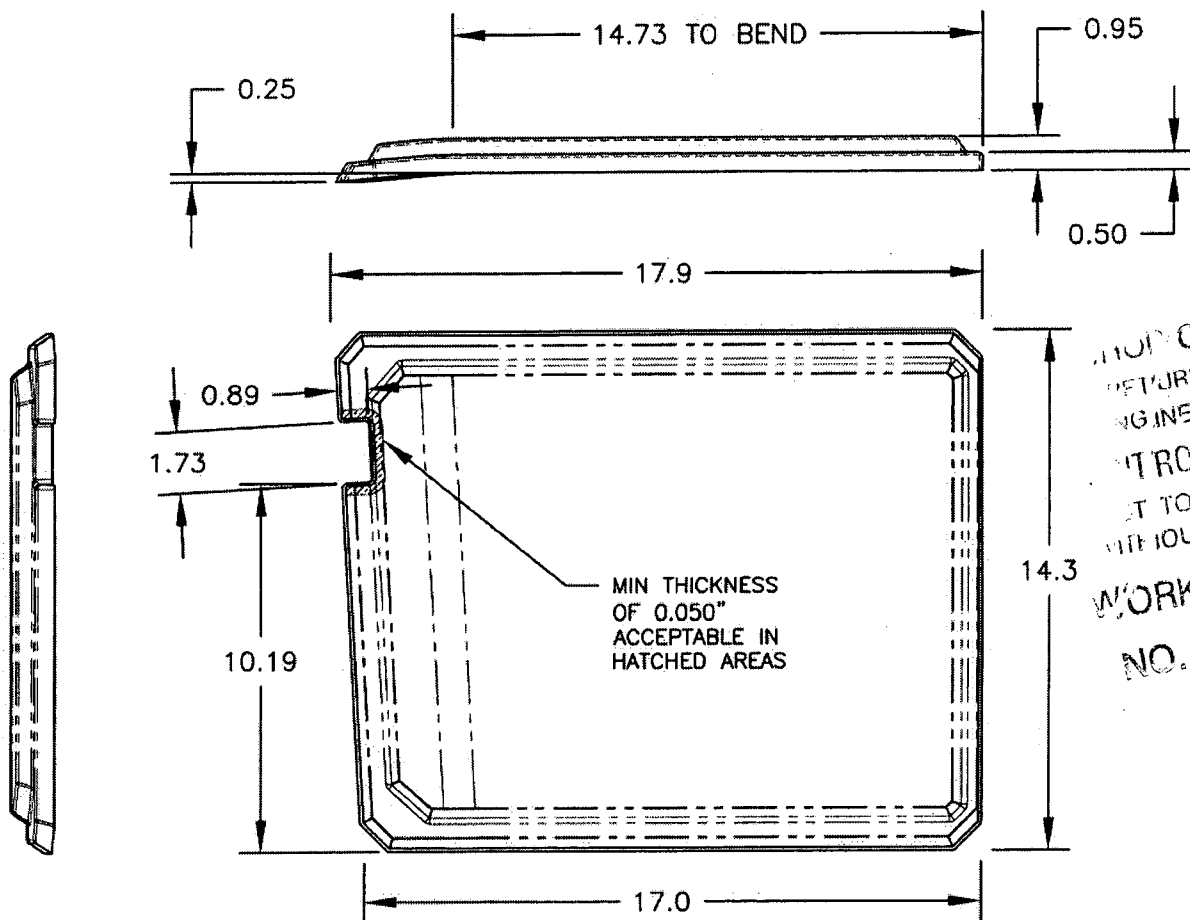
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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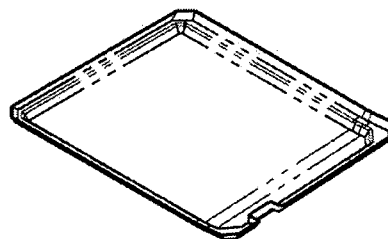


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HS</i>	APPROVED <i>HS</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



STOP COPY  
RETURN TO  
ENGINEERING  
CONTROL COPY  
NOT TO BE LEND  
WITHOUT NOTICE  
WORK ORDER  
NO. 25121

RELEASED  
05.12.01. *HS*



**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**  
**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2  
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.  
2699, 5<sup>ème</sup> Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Telephone: (819) 533-5788  
Warehouse: MAIN

Invoice #	9876
Customer #	DART

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/01/06	05/12/05	4333	Linda Lacelle		PO00000192		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	20	DKC134-0044	Floor Protect Part 1 N° D3281-1 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32263			
20	0	20	DKC134-0045	Floor Protect Part 2 N° D3281-2 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32264			
20	0	20	DKC134-0046	Floor Protect Part 3 N° D3281-3 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32265			
20	0	20	DKC134-0047	Floor Protect Part 4 N° D3281-4 ( F6006 ) Selon dessin D3181 Rev.: B JOB # 32266			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department




AQ-357



Date: Mercredi, 2005-12-21 14:19:43  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	FLOOR PROTECTOR
Numéro Job :	32264	Numéro Article :	DKC134-0045
Numéro Soumission :	2384	Numéro Dessin :	D3281
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2005-12-21 No. B.V. :	Révision dessin :	B
Prsht Rev. :	NC	Matériel :	F6006
Prem. fois :	- - Type :	Date Dûe :	2005-12-28
Job précédente :	32056	Qté:	20 UdM: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce: D3281-2 Process Sheet Rév.: 00		

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
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 Commentaire Qty.: 0.167 UNITE(s)/Unit  
 Lexan F6006 Noir N° 700 48"

APL0016



1-5327-1

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

# Bon achat: 5327

N° de Lot:

2.0	SÉCHAGE/ANEAL
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 Commentaire Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs  
 SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la carte de température le numéro de Job du matériel au séchage.


# de cuisson: 4710 + 4714

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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 Commentaire Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs  
 TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 13 Date: 13-1-06 Sceau: Quantité: 7 Date: 16-1-06 Sceau: 

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 32264Nom Dessin: FLOOR PROTECTOR  
Numéro Article: DKC134-0045

Numéro Job:



# Séq.: Machine ou Opération: Description :

4.0 THERMOFORMAGE2 THERMOFORMAGE DES PIÈCE DART

Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
THERMOFORMAGE DES PIECESFaire le thermoformage du " Floor Protector " N° D3281-2 à l'aide du moule N° D3281-2T1 sur le  
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 13 Date: 13-1-99 Sceau:



1222p-

Quantité: 7 Date: 16-1-96 Sceau:



F.O. 13 JANV 96



5.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-2 à l'aide du gabarit de trimage N° D3281-2T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 20 Date: 24-01-95 Sceau:



F.O. 18-01-2000

N.C.



Quantité: Date: Sceau:

6.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 26-01-96 Sceau:



7.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 32264Nom Dessin: FLOOR PROTECTOR  
Numéro Article: DKC134-0045

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

N° de pièce: D3281-2

N° de Job: \_\_\_\_\_

Date de fabrication: \_\_\_\_\_

Sceau d'inspection.

Quantité: 20 Date: 27-01-06 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-2

Date de fabrication: \_\_\_\_\_

N° de job: \_\_\_\_\_

Quantité: 20 Date: 27/1/06 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_